

June 11

Work Order ID 83726

83726

Page 1

April-24-12 1:24:23 PM

Item ID: D350-591-312

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, Long RH

Start Date: 24/04/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/04/24

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG004

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

3-Grind End Plate flush

119185
120854

10 0

12.05.10

12.05.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

x10 12 05 10

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

12 05 10

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

10 12 05 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NS2

Start Date: 24/04/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150						10	Ø		12.05.12
QC	Memo	0.00							
Quality Control									
180		0.00							
180	Large Fab					10	Ø		12.05.12
Large Fab	Memo	0.00							12.05.14
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272								
	A/RAluminum Rod 119785								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

12.05.14

W/O:		WORK ORDER CHANGES					
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N900040100

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Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step, Long RH

Start Date: 24/04/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		8/2/05/15		10			12.05.14
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8/2/05/15		(+10)			RH
210 *210* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				(10)			7/6 12-5-15

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
270									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-312								
	Location: _____								

Rev B.

12/5/17

10
PM

10x

12-5-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop ***NS2***

Start Date: 24/04/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 08/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

12/5/23 *[Signature]*
MCS 12/05/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 83726

83726

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:cC

IPP Rev:D

fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1

Manufactured

No

110

Each

20.0000

1

10

D3272-1

Step

**

Ac 12.04.30

Location

Loc Qty

Loc Code

ST

-10

WA

883730

30

81312

10

81313

10

(10)

D3067-1

Manufactured

No

110

Each

187.0000

1

10

D3067-1

End Plate

**

12.05.10

Location

Loc Qty

Loc Code

WA

123

78608

4

80881

45

81969

74

WA016

64

67582

2

68214

1

79607

1

83053

60

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

Work Order ID: 83726

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Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 10.00

Required Qty: 10.00

D3219-1

Manufactured No

110

Each

323.0000

2

20

D3219-1

Plate

**

12.05.10

Location

Loc Qty

Loc Code

WA

84

82221

84

WA016

118

73410

12

77674

6

81292

80

82059

20

WA017

121

81971

121

D3066-1

Manufactured No

180

Each

101.0000

2

20

D3066-1

Spacer

**

12.05.12

Location

Loc Qty

Loc Code

WA

101

81968

101

MS20600-AD4W4

Purchased No

180

Each

3,044.000

16

160

MS20600-AD4W4

Rivets

**

12.05.12

Location

Loc Qty

Loc Code

ST321

3044

121011

9

121340

1035

121444

2000

April-24-12 1:24:27 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 83726

83726

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 10.00

Required Qty: 10.00

D3065-041

Manufactured No

180

Each

19.0000

1

10

D3065-041

Step Leg Assembly Hi

**

B83368 x 7 Ae
B80880 x 3 12.05.12

Location

Loc Qty

Loc Code

WA

19

66149

0

78798

18

79336

1

D3067-1

Manufactured No

180

Each

187.0000

1

10

D3067-1

End Plate

**

12.05.14

Location

Loc Qty

Loc Code

WA

123

78608

4

80881

45

81969

74

WA016

64

67582

2

68214

1

79607

1

83053

60

AN3-35A

Purchased No

250

Each

147.0000

2

20

AN3-35A

Bolt

**

12/5/17

Location

Loc Qty

Loc Code

ST353

147

120644

50

120717

50

121068

47

20 S u c

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 10.00

Required Qty: 10.00

D3235-1 Manufactured No 250 Each 69.0000

2 20

**

81970

D3235-1

Mounting Lug

AD

Location

Loc Qty

Loc Code

ST

69

78787

69

D3278-041 Manufactured No 250 Each 83.0000

1 10

**

D3278-041

Support Assembly

AD

Location

Loc Qty

Loc Code

ST471

3

78795

3

ST481

80

82015

40

83361

40

AN960JD416 NAS1149D0463J Purchased No 250 Each 10.0000

16 160

**

1121255

AN960JD416

Washer

AD

Location

Loc Qty

Loc Code

ST351

10

116289

10

AN960JD516 NAS1149D0563J Purchased No 250 Each 0.0000

4 40

**

1119546

12/5/17

AN960JD516

Washer

AD

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Shop Packet Print

Page 4

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D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 10.00

Required Qty: 10.00

AN5-36A

Purchased

No

250

Each

186.0000

2 20

**

AN5-36A

Bolt

Location

Loc Qty

Loc Code

340

100

121181

100

ST340

86

120187

36

120731

50

D2618

Manufactured

No

250

Each

220.0000

2 20

**

D2618

Bushing

Location

Loc Qty

Loc Code

ST012

220

76130

2

78537

18

80474

200

D2230-3

Manufactured

No

250

Each

147.0000

4 40

**

D2230-3

Lug

Location

Loc Qty

Loc Code

ST480

147

53881

4

70973

1

81558

142

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 10.00

Required Qty: 10.00

D2856-400

Manufactured No

250 f

353.5345 1.2 12

D2856-400

Abrasion Strip

**

Location

Loc Qty

Loc Code

ST403	216
81875	216
ST409	137.5345
63735	0.6696
68076	0.3149
71164	8.46
79551	128.09

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased No

250 Each

3,512.000

**

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300	3512
117441	16
117885	32
118451	5
118927	3
119017	1384
119075	158
121349	914
1214444	1000

20

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D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 24/04/2012

Required Date: 08/05/2012

Start Qty: 10.00

Required Qty: 10.00

AN4-13A

Purchased

No

250

Each

1,099.000

8 80

AN4-13A

Bolt

**

Location

Loc Qty

Loc Code

ST357

1099

119449

39

120187

19

120422

141

120770

400

124162

500

MS21042L5

Purchased

No

250

Each

1,337.000

2 20

MS21042L5

Nut

**

Location

Loc Qty

Loc Code

ST300

1337

116105

5

116548

43

117611

30

119109

1259

MS21042L4

Purchased

No

250

Each

6,002.000

8 80

MS21042L4

Nut

**

Location

Loc Qty

Loc Code

ST300

6002

116188

5

119017

4

119075

993

121011

2000

121444

3000

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

4 40

AN960JD10

Washer

**

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DESIGN <i>gp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *H*

△
B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005.4.3
BLACK ANTI-SKID PAINT PER DART QSI 005.4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

12/04/24
NO. 83326 MJS
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

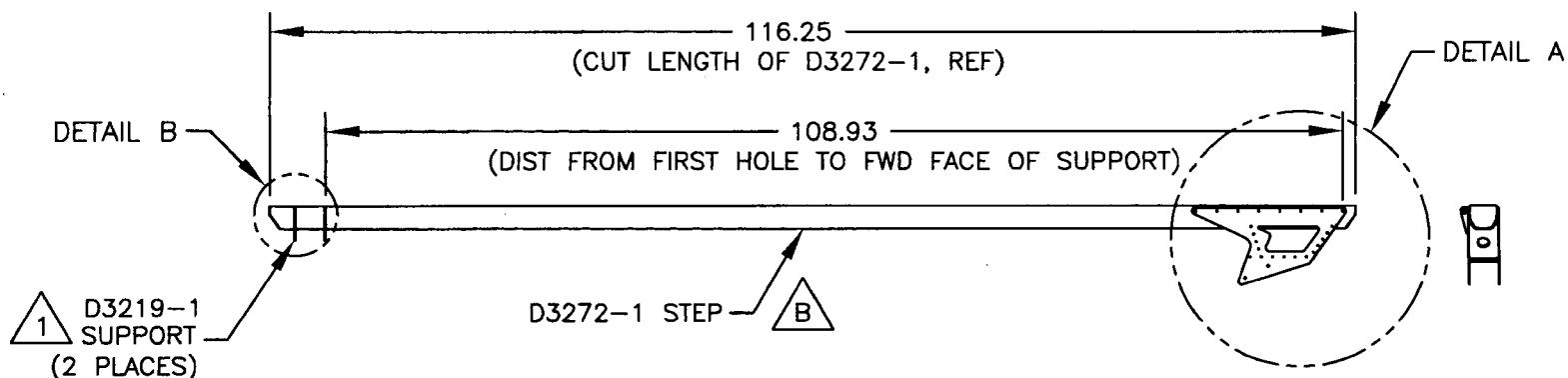
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

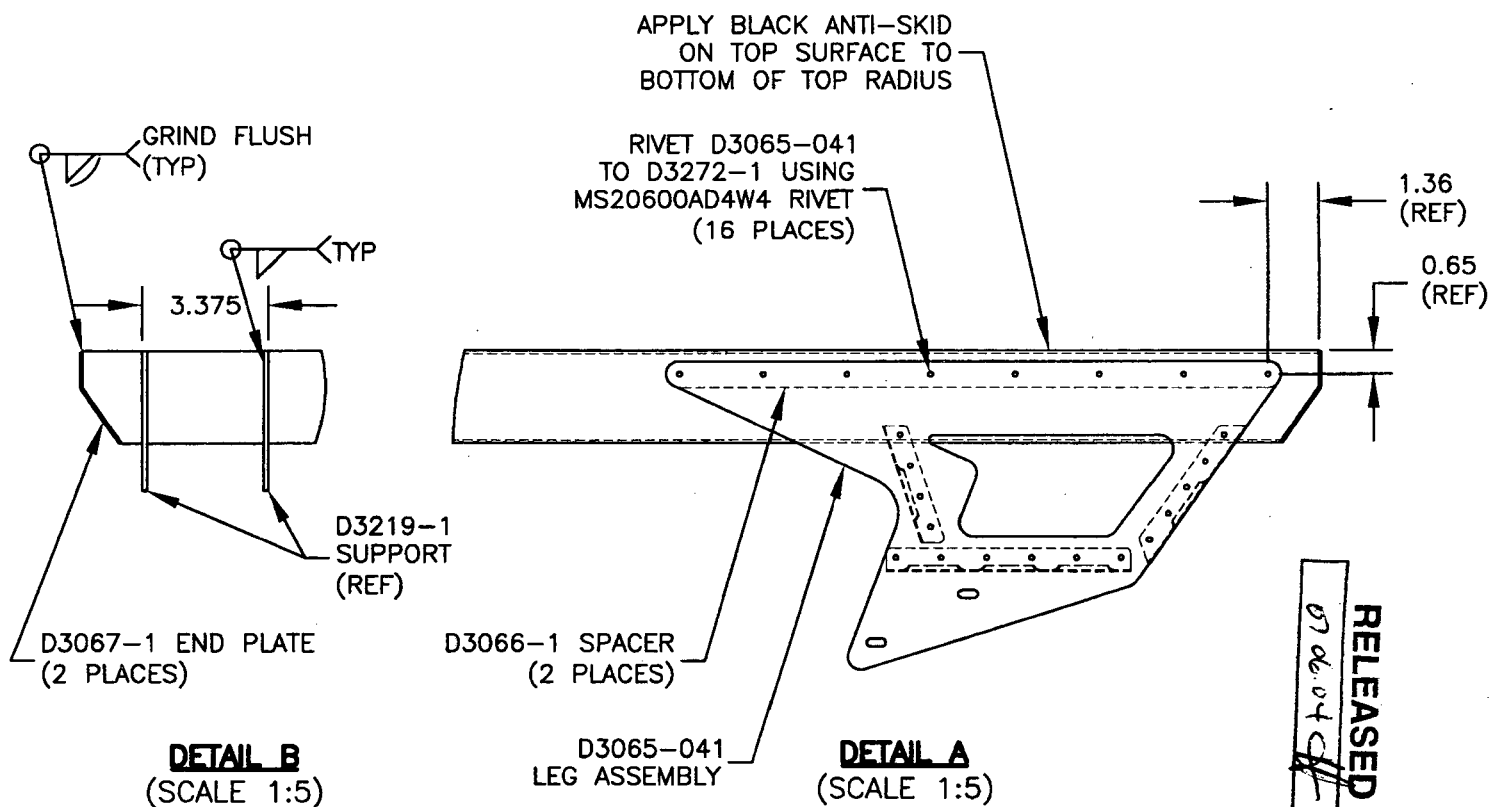
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83726

DART

D3272-041 STEP ASSEMBLY (LH. SHOWN)
 D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DESIGN	90	DRAWN BY		DART AEROSPACE LTD
CHECKED	CE	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE	1:20	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

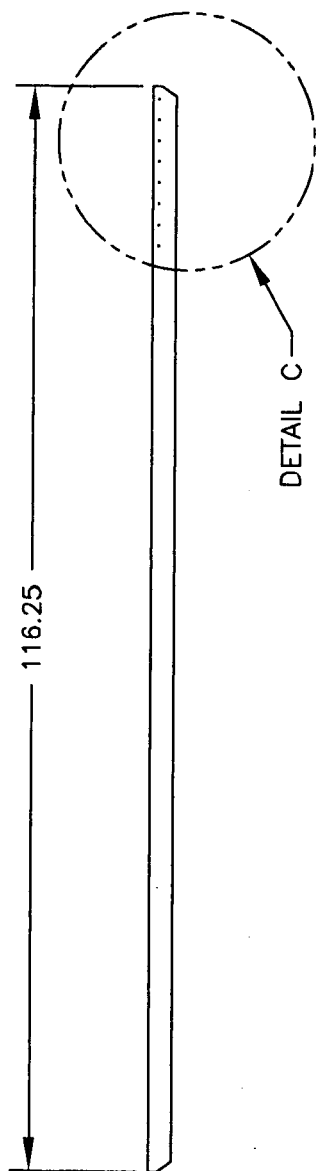
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

03726



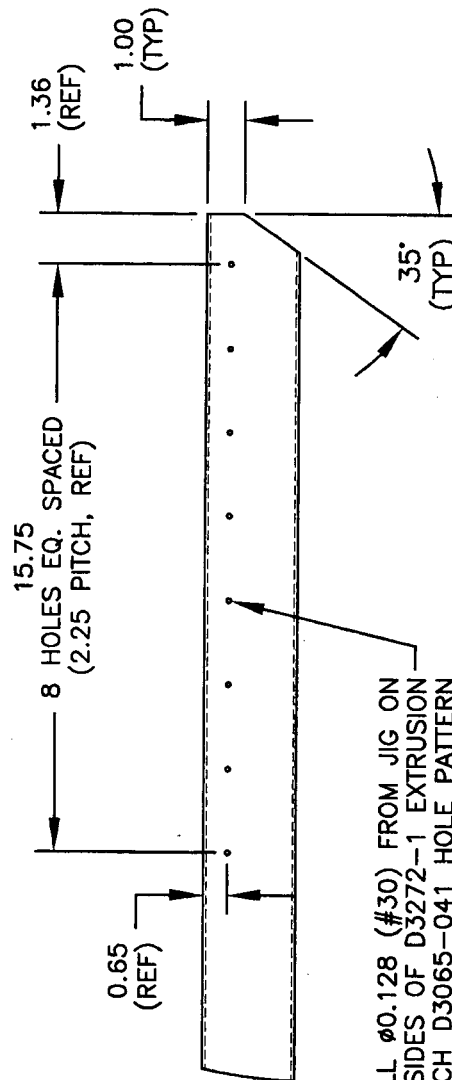
DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

RELEASED

07.06.04

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™ , Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™ , Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™ , Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™ , Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™ , Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™ , Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™ , Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™ , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4*13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.